

Date: Friday, 10/20/2006 11:09:52 AM
 User: Kim Johnston

Process Sheet

| | | | | | | |
|-----------------------|---------------------------------------|--|------------------|--------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : CLAMP | | |
| Job Number | : 29085 | | | | | |
| Estimate Number | : 10192 | | | | | |
| P.O. Number | : N/A | | Part Number | : D2171 | | |
| This Issue | : 10/20/2006 S.O. No. : N/A | | Drawing Number | : D2171 REV. D | | |
| Prsht Rev. | : NC | | Project Number | : N/A | | |
| First Issue | : N/A | | Drawing Revision | : D | | |
| Previous Run | : 27244 | | Material | : N/A | | |
| Written By | | | Due Date | : 11/15/2006 Qty: 100 Um: Each | | |
| Checked & Approved By | | | | | | |
| Comment | : Est: F 01.1.29 Reformat SM/EC | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|---|---------------------------------|
| 1.0 | PG | PURCHASING |
| | | |
| | Comment: PURCHASING Issue P/O: 2299 Laser cut as per Dwg D2171 Material: 304/316 SS 0.063" thick Material release note required | <i>(Loc) 10/10/20 (100)</i> |
| 2.0 | D2171F | Clamp |
| | | |
| | Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) CLAMP | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
| | | |
| | Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached | |
| 4.0 | QC6 | DIMENSIONAL CHECK |
| | | |
| | Comment: DIMENSIONAL CHECK (4.158" center to center) | <i>10/11/05 (100)</i> |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| | | |
| | Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Deburr 2- Bend as per Dwg D2171 3- Tumble | <i>mf. 06-11-20 (99)</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D2171 PAR #: N/A Fault Category: Supplier/Gff NCR: Yes No DQA: PD Date: 06/11/24
 QA: N/C Closed: X Date: 06/11/24

| | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|--|-----------------|---------------------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06-11-17 | 4.0 | Supplier made parts using .063 SS. 301, AMS SS16. | <u>PD</u> <u>Boffy</u> | - Notify supplier, so next time the material will match the drawing. - Material is acceptable per E-mait. | <u>06/11/17</u> | <u>J</u> <u>PD</u> <u>06/11/17</u> | <u>Boffy</u> | <u>06/11/17</u> |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 10/20/2006 11:09:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 29085

Part Number: D2171

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 06/11/06 99

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST219

10/11/06 99

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/11/06 98

Job Completion



10/11/06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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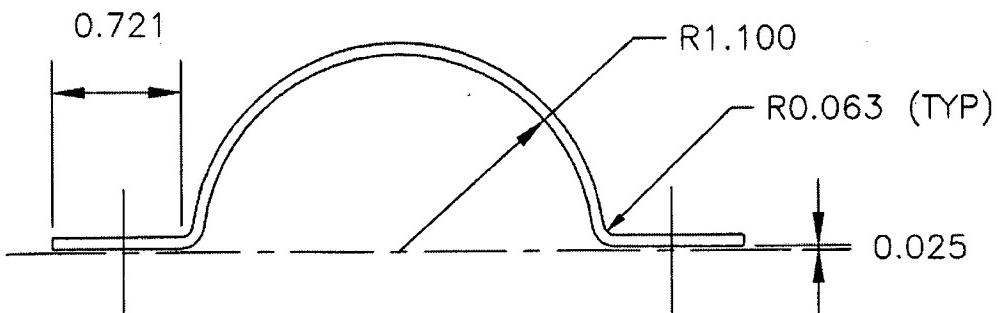
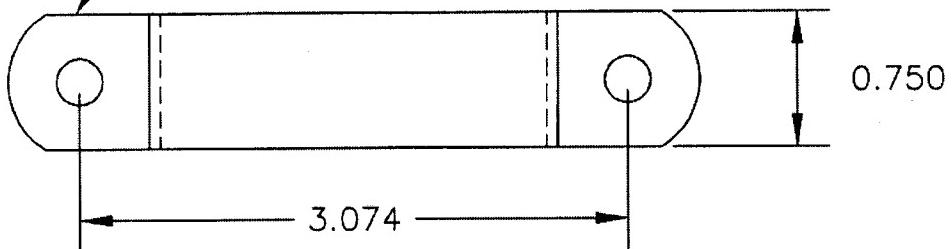
NOTE: Date & initial all entries

DART

| | | | |
|----------------------|--------------------------------|--|------------------------|
| DESIGN Bw | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA | |
| CHECKED <i>CP</i> | APPROVED <i>KE</i> | DRAWING NO. D2171 | REV. D SHEET 1 OF 1 |
| DATE 99.03.08 | | TITLE CLAMP | SCALE 1:1 |
| B | 96.01.29 | REDRAWN | |
| C | 97.05.14 | RADIUS CHANGED, CUSHION ADDED | |
| D | 99.03.08 | REMOVE CUSHION (TSR A890) 4.158 WAS 4.888 | |

RELEASED
99.03.11 KE

PUNCH ENDS PER SPEC
CONTROL DRAWING D2727



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *29085*

MATERIAL: 304/316 SS 0.063 THICK
FLAT LENGTH: 4.968 END-END
4.158 HOLE-HOLE



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CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

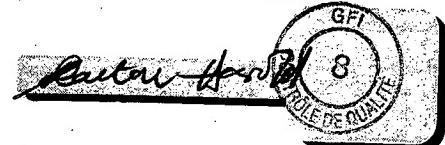
| | | | | | |
|-----------------|----------|----------------|--------------------------|---------------|---------------------|
| CERTIFICATE NO. | 2 | OUR JOB NO | J0151142 | SHIPPING MEMO | 0350224 |
| ITEM | QUANTITY | PURCHASE ORDER | PART NUMBER | REV | NAME |
| | 100 PCS | PO00002299 | D2171 | D | CLAMP |
| MATERIAL | | | SUPPLIED BY | | DWG ISSUE |
| S.S.T 301 | | | ROLLED ALLOYS / AK STEEL | | H/N # 7360176 ATT'D |

| | PROCESS | PROCESSOR | RELEASE NOTE # |
|---|---|-----------|----------------|
| 1 | FIRST ARTICLE INSPECTION REPORT ON FILE | GFI | CONFORMS |
| 2 | | | |
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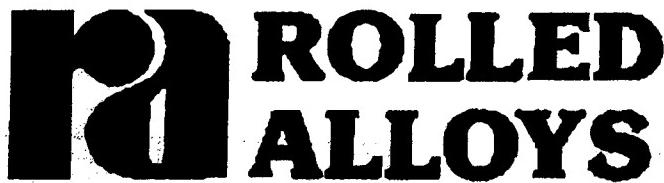
WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 14 NOVEMBER 2006

G.F.I. Q.C. REP.



528-0t



Heat and Corrosion Resistant Alloy Specialists

2283 Argentia Road, Unit 6
Mississauga, Ontario CANADA L5N 5Z2
Phone: 905-363-0277 Fax: 905-363-0283

CERTIFICATE OF COMPLIANCE

Date: AUGUST 9, 2006

Sold to: GFI INC.

Ship to: 180 AVENUE LABROSSE
POINT CLAIRE, QC
H9R 1A1

PO: 60753

Material: .060/.066" THICK SHEET 301 SS 77 lbs.
1 PC 36"x 120"
.063"302 ANN ✓
MIL S 5059

Heat: 7360176

Spec: AMS 5516
CANADAIR APPROVED SOURCE

This is to certify that the material furnished under the above purchase order meets all the requirements of the specification as specified on your purchase order.

Yours Faithfully,

H.Khan, P.Eng
Q.A.Manager

AK Steel Corporation
Metallurgical Test Report
Coshocton Works
Coshocton, OH 43812

Page 1

Load No. 7883163
SIN No. 7883163

| | | | | | | | | | | | | | | |
|---|---------------------|---|-----------------------|---|-------------------------------|--|-------------------------------|----------------------------------|----------|-----------|--|--|--|--|
| CUSTOMER | | FERGUSON METALS INC. 3475 SYMMES ROAD HAMILTON, OH 45015 | | FERGUSON METALS INC FERGUSON METALS INC/AERO METAL PROCESSING DIVISION 3475 SYMMES ROAD HAMILTON, OH 45015 | | MILL ORDER NO. 271940-033 PROCESSOR ORDER NO. 01008517 PART NO. 11156 ENGLISH UNITS -PRODUCT- METRIC UNITS J522 NOM 36.000 X COIL | | BUYERS ORDER NO. D1018517 | | | | | | |
| SKID ID | PIECE | HEAT | PARENT COIL ID | NET WEIGHT | | | | | | | | | | |
| SKID#59479 | 1 | 7368176 | 0686188-02B | 12,970 LBS. 5,883 KG. | | | | | | | | | | |
| TOTAL SKIDS | TOTAL PIECES | | | TOTAL NET WEIGHT | | | | | | | | | | |
| 1 | 1 | | | 12,970 LBS. 5,883 KG. | | | | | | | | | | |
| L-Ladle Analysis of Heat P-Product Analysis of Parent Coil | | | | CHEMICAL ANALYSIS | | | | | | | | | | |
| ID | C | MN | P | S | SI | CR | N | MO | N | CU | | | | |
| L 7368176 | .012 | 1.30 | .025 | .001 | .45 | 18.24 | 8.61 | .32 | .037 | .35 | | | | |
| SHIPPING DATE: 04/18/2006 | | | | REMARKS: THIS MATERIAL WAS MELTED AND MANUFACTURED IN THE U.S.A. NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL. COILED PRODUCTS CONTAIN NO WELDS MATERIAL MEETS REQUIREMENTS OF TYPES 304 & 304L FOR REFERENCED SPECIFICATIONS | | | | | | | | | | |
| PRODUCT DESCRIPTION | | | | | | | | | | | | | | |
| CR SHT TYPE 302/304/304L STAINLESS #2B FINISH SLIT EDGE * AMS 5513 H WITH AK STEEL DOCUMENTED EXCEPTIONS DATED 07/11/05 TO PARAGRAPHS * ASTM A 240 -04 EX PARA 3.1.9 ELONG WILL BE DETERMINED BY ASTM E 8 * AMS 5511 H WITH AK STEEL DOCUMENTED EXCEPTIONS DATES 07/11/05 TO PARAGRAPHS * AMS 5516 H WITH AK STEEL DOCUMENTED EXCEPTIONS DATED 03/30/05 TO PARAGRAPHS-1.2. PRODUCT END USE, 2. SPE C. REVIEWS AND CERTIFICATION; 3.4 * ASTM A 666 -03 * MILS-5059 D-AMEND-3 * UNS-S30403 9TH EDITION * FMX-304L/304/302 ISSUE 7, 2/13/06 * ASME SA-240 SECTION II PART A (2004 ED, 2005 ADDENDA) EX PARA 3.1.7 DIMENSIONAL TOLS FROM ASME SA-480 2004 DO NOT APPLY * UN S-S30400/S30200 | | | | | | | | | | | | | | |
| PARENT COIL ID | POS (WT) | DIR (L, T, D) | COND | % ELONG 2 INCH MEASURED | TENSILE STRENGTH (KSI) | V.S. 3% OFFSET (KSI) | ROCKWELL HARDNESS Tail | ROCKWELL HARDNESS Front | | | | | | |
| 0686188-02B | 7 | T | A.S.T.M | 58.6 | 83.2 | 37.6 | B 78 | B 80 | | | | | | |
| REVIEWED BY Q.C. <i>[Signature]</i> Date <u>04/14/06</u> by <u>lun</u> | | | | | | | | | | | | | | |
| ***CONTINUED ON NEXT PAGE*** | | | | | | | | | | | | | | |

FERGUSON METALS, INC.
 This is to certify that in accordance with the terms and conditions of the purchase order number 0686188 dated 03/30/05, the material shipped on account of this purchase order conforms to the following:
 3475 Symmes Road
 12A Trobridge Drive
 Hamilton, OH 45015
 Billed to: CT 0686188

26 X120
 P.O. 72435KK
 Sales#: 01083765
 QTY: 1

132 ANN .060-.064 AMS 5516
 Prime G.F.I. INC.
 7360176
 Dated: 08/09/05

FERGUSON METALS

PAGE 10/17
05/11/2018

|  AK Steel <i>Lynne Harper</i> | | | | AK Steel Corporation Metallurgical Test Report Coshocton Works Coshocton, OH 43812 | | | | Page 2 | | | | |
|---|--|-----------|---------------|---|-----------------------|----------------------|-------------|--|--|--|--|--|
| | | | | | | | | Load No. 7883163 SRN No. 7883163 | | | | |
| R M E G O S H I P T O | | | | FERGUSON METALS INC 3475 SYMMES ROAD HAMILTON, OH 45015 | | | | MILL ORDER NO. 271940-0533 PROCESSOR ORDER NO. 01008517 BUYERS ORDER NO. 01008517 PART NO. 11136 ENGLISH UNITS - PRODUCT:- METRIC UNITS AS20 NOM 34809 X COIL | | | | |
| PARENT COIL ID | | POS (P/T) | BRK (L, T, D) | COND | ASTM A 262 PRACTICE E | GRAIN SIZE ASTM E111 | BEND 180 IT | | | | | |
| 0686163-02B | | T | | A.S.T.M | PASS | 8.50 | PASS | | | | | |
| 0686163-02B | | Y | | A.S.T.M | PASS | 8.50 | PASS | | | | | |
| THE CHEMICAL ANALYSIS AND PHYSICAL OR MECHANICAL TESTS REPORTED ABOVE ARE CORRECT AS CONTAINED IN THE RECORDS OF THE CORPORATION. ALL TESTING IS DONE IN ACCORDANCE WITH ASTM STANDARDS UNLESS OTHERWISE NOTED | | | | | | | | THIS CERTIFIED TEST REPORT HAS BEEN DELIVERED TO A CONCERNER OF MATERIAL PURCHASED FROM AK Steel Corporation. SHOULD THE POSSIBILITY OF RETENTION ON DELIVERY OF THIS REPORT TO A THIRD PARTY IT MUST BE RECEIVED BY AND LEAVE THE NAME OF SUCH CONCERNER. | | | | |
| AK Steel Corporation | | | | 2006Q2/0010 5/09 | | | | SIGNED <i>Geoffrey Raymond</i> APPLICATION ENCLOSED DATE 04/11/2006 TIME 21:19 PM | | | | |

FERGUSON METALS, INC.
Authorized Signature
[Signature]

This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following:
3475 Symmes Road
112A Trowbridge Drive
Hamilton, OH 45011
Bethel, CT 06801

TO: ALAN
P.O.: 174365K
Sales #: 01008516
QTY: 1

Customer: GFI, INC.
Heat: 216076
Shipped: 05/06/06

Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, November 16, 2006 6:04 PM
To: 'Jason Murdoch'
Cc: 'L Lacelle'
Subject: RE: D2171 clamps

For the D2171 clamps, it is acceptable to use AISI 301 SS 0.063" thick per MIL S 5059.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Thursday, November 16, 2006 5:17 AM
To: 'David Shepherd'
Cc: 'L Lacelle'
Subject: D2171 clamps

Good morning Dave. I received some clamps this morning and on the supplier certs, they state that the material used was .063 S.S. 301; MIL S 5059; and also is Canadair approved spec for AMS 5516. I'm not sure if this is acceptable because I can't find it as an equivalent material.

jmurdoch@dartaero.com
Q.C. COORDINATOR

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.14.6/535 - Release Date: 11/15/2006

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.14.6/536 - Release Date: 11/16/2006